

0.039 each



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4776-5

Job Sheet 177196



Part No: D4776-5

Job Qty: 60 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/8/18

Job Tracking No:

Due Date: 6/15/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV D SHEET 3 IPP REV:A NEW ISSUE 13-08-30 JLM VERIFIED BY:DD IPP REV:B 13.09.26 AS PER
REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea	6/15/18	6/15/18	0.00	0.00	Start Up Machining-3		18/07/09
100	Doosan	60 pcs	6/15/18	6/15/18	0.05	3.35	Doosan		18/07/09
120	QC	60 pcs	6/15/18	6/15/18	0.00	0.00	QC8		38
130	HandFinish	60 pcs	6/15/18	6/15/18	0.00	0.29	HandFinish1		38
140	QC	60 pcs	6/15/18	6/15/18	0.00	0.00	QC7-4		38
150	Packaging	60 pcs	6/15/18	6/15/18	0.00	0.00	Packaging3-2		38
160	QC21-SA	60 Ea	6/15/18	6/15/18	0.00	0.00	QC21		38

Part Op 100 - 1-Turn as per Folio and Dwg
Descriptions:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.500	6061-T6 Round Bar .500"	1.2000 ft (.02 ea)	90-Start up Operation	5046349

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R0.500	1	33	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.130Inches ± 0.030	0.160 0.100		
2	Spacer	0.250Inches ± 0.030	0.280 0.220		
3	Spacer	0.625Inches ± 0.010	0.635 0.615	Diameter	
4	Spacer	0.438Inches ± 0.010	0.448 0.428	Diameter	
5	Spacer	0.203Inches + 0.005 - 0.001	0.208 0.202	Diameter	



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Container No: S090210



Part: D4776-5

Job No: 177196

Serial No/Batch: S090210

Revision:

Inspector:

Exp Date:

Instructions:

Date: 07/09/18